

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008888**Date Inspected:** 30-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi/ Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay #1**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(CB201A-007-005, 017)

**Bay#6**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(SP3010-001-064)

**Segment 3E**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(SP063-001-050)

-(SP051-001-043)

-(SP063-001-088)

-(SP210-001-059)

-(BP005-001-058)

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

-(BP004-001-050)

-(BP011-001-032)

This QA inspector observed the following work i-n progress:

Bay#2

FCAW welding of weld joint FB3062-001-003, 004, 007, 008, 009, 012, 013, 016 located on FB3062-001. Welder is identified as 045203 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3062-001-044, 001, 021, 005, 026, 006, 029, 010, 030 located on FB3062-001. Welder is identified as 045203 (2F/3F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3067-002-001, 003~013 located on FB3067-002. Welder is identified as 062438. ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3067-001-001, 003~013, located on FB3067-001. Welder is identified as 045209 (3F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3067-001-015, 018~028 located on FB3067-001. Welder is identified as 045209 (3F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Cross Beams Update:

CB014-Bay#3-

SAW welding of weld joint CB202E-014-001 located on CB-014. Welder is identified as 058100 (1G). ZPMC QC-CWI is identified as Chen Xi. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint CB202E-014-002 located on CB-014. Welder is identified as 058100 (1G). ZPMC QC-CWI is identified as Chen Xi. The welding variables recorded by QC appeared to comply with the Applicable WPS.

CB008-Bay#6-

FCAW welding of weld joint FB205-017-026 located on CB-008. Welder is identified as 058174 (3G/3F). ZPMC QC-CWI is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB205-018-030 located on CB-008. Welder is identified as 058174 (3G/3F). ZPMC

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

---

QC-CWI is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB205-017-030 located on CB-008. Welder is identified as 058174 (3G/3F). ZPMC QC-CWI is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

CB012-Bay#8-

FCAW welding of weld joint FB204-033-067, 068 and FB204-034-067, 068 located on CB-012. Welder is identified as 066687(2F). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-033-067, 068 and FB204-034-067, 068 located on CB-012. Welder is identified as 066687(2F). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-033-049, 058 and FB204-034-058 located on CB-012. Welder is identified as 066687(2F). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-033-053, 054 and FB204-034-053, 054 located on CB-012. Welder is identified as 066687(2F). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-035-067, 068 and FB204-036-067, 068 located on CB-012. Welder is identified as 066687(2F). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-035-049, 058 and FB204-036-049, 058 located on CB-012. Welder is identified as 066687(2F). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-035-054 and FB204-036-054 located on CB-012. Welder is identified as 066687(2F). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

---

## WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

---

remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

---